Work Order ID 92338

Monday, October 29, 2012 11:43:55 AM

92338

Item ID: D4541-5
Revision ID:
Item Name: Bracket

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 10/29/2012 **Start Qty:** 22.00 *22*
Required Date: 10/31/2012 **Req'd Qty:** 22.00 *22*
Reference: ALODINE

Cust Item ID:
Customer:

Approvals: **Process Plan:** MF **Date:** 12-10-29 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Cancelled

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D4541	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
170 *170* Packaging Packaging		0.00
	Memo PULL FROM STOCK D4541-5 X 2 -2 X B78277 -20 X B 91422 BRING TO ALODINE	0.00
180 *180* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00
	Memo	0.00

already done Alodine

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 92338

Monday, October 29, 2012 11:43:55 AM

92338

Item ID:	D4541-5	**Accept**	*N900040100*
Revision ID:			
Item Name:	Bracket		
Start Date:	10/29/2012	**Start Qty:** 22.00	*22*
Required Date:	10/31/2012	**Req'd Qty:** 22.00	*22*
Reference:	ALODINE		

Setup **Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run **Start** *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00							
	Memo	0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location:_______	0.00							
	Memo	0.00							
210 *210* QC Quality Control	QC21- Final Inspection ; Work Order Release	0.00							
	Memo	0.00							

MF 12-10-09

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
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☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

Monday, October 29, 2012 11:43:54 AM

Work Order ID: 92338

Parent Item: D4541-5

Parent Item Name: Bracket

Start Date: 10/29/2012 **Required Date:** 10/31/2012

Start Qty: 22.00 **Required Qty:** 22.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-5 Bracket		Manufactured	No				Each	-15.0000		22			

Location	Loc Qty	Loc Code
ST163	-15	
91422	-15	

20 x 91422
2 x 78277

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

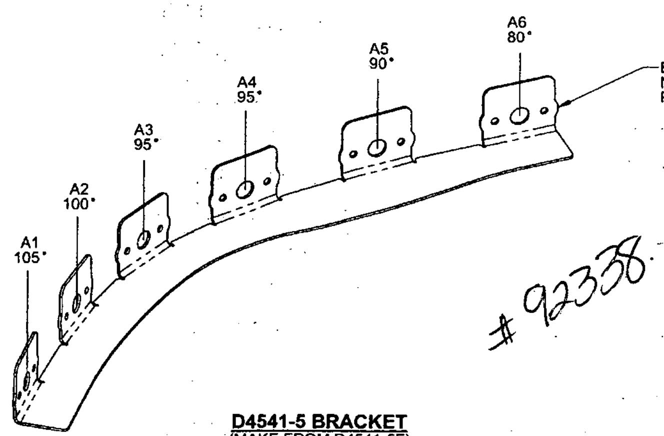
QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

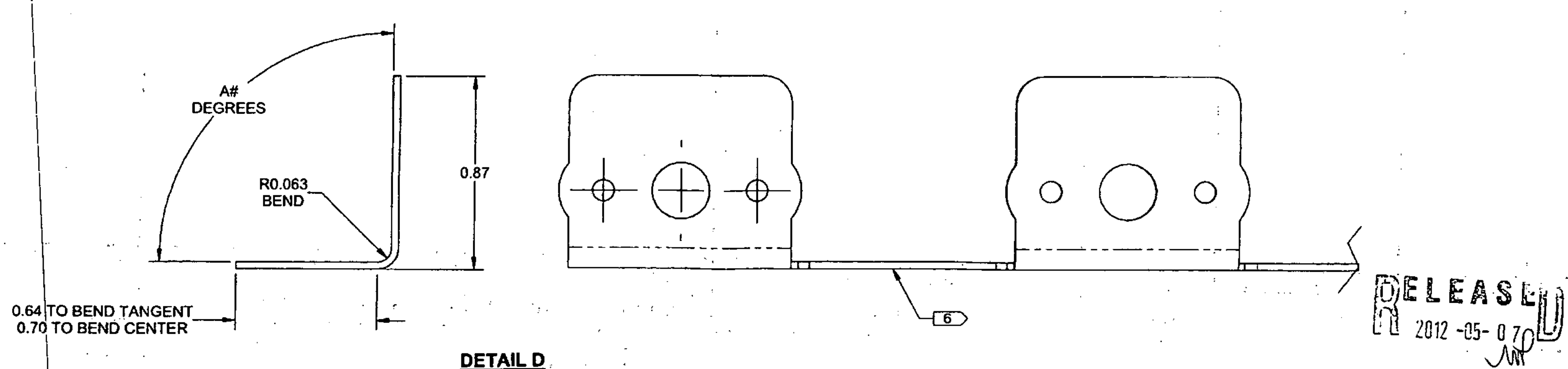
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
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Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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Landing Gear	General			
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D4541-5 BRACKET
(MAKE FROM D4541-5F)



DETAIL D
BEND DETAIL
SCALE 2X

NOTES:
1) MATERIAL: MAKE FROM D4541-5F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4541 — REV. C — SHEET 4 OF 7
MFG. APPR.		
APPROVED		TITLE BRACKET — SCALE NTS
DE APPR.		
DATE	12.02.20	

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
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	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Operator ☐									
Material ☐									
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Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

List Lots

Monday, October 29, 2012 10:44:31 AM

Criteria : Item ID: d4541-5 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D4541-5 Bracket	Main Warehouse ST112	78277	10/26/2012	2.0000				
	Main Warehouse ST163	91422	10/26/2012	20.0000				
			Total:	22.0000				

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ________	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐
NCR No. ________		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

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